

Date: Thursday, 2/14/2008 11:01:35 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: SADDLE SPACER		
Job Number	: 37443					
Estimate Number	: 10376					
P.O. Number	:			Part Number	: D2885	
This Issue	2/14/2008	S.O. No. :		Drawing Number	: D2885 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	:/ /	Type :	SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: 37342			Material	:	
Written By	:			Due Date	3/15/2008	Qty: 60 Um: Each
Checked & Approved By	:					
Comment	: Est A 99.10.12 New Issue EC					
	Est Rev:B Now 6060-T6 06-06-23 JLM					
	Est Rev:C waterjet 06-07-23 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0270 sf(s)/Unit Total : 1.6191 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.080" Thick Batch <u>106320</u> HB 8-2-20	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2885 Dwg Rev: <u>B</u> B 8-2-20 Prog Rev: <u>B</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:35 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 37443

Part Number: D2885

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

~~QC5~~
QC3



INSPECT WORK TO CURRENT STEP

QC3-26



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 52

8h/24

SD

1041X

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

+ 108102/26

Job Completion



U 8,8272

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37443
Description: Saddle Spacer	Part Number:	D2885
Inspection Dwg: D2885	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

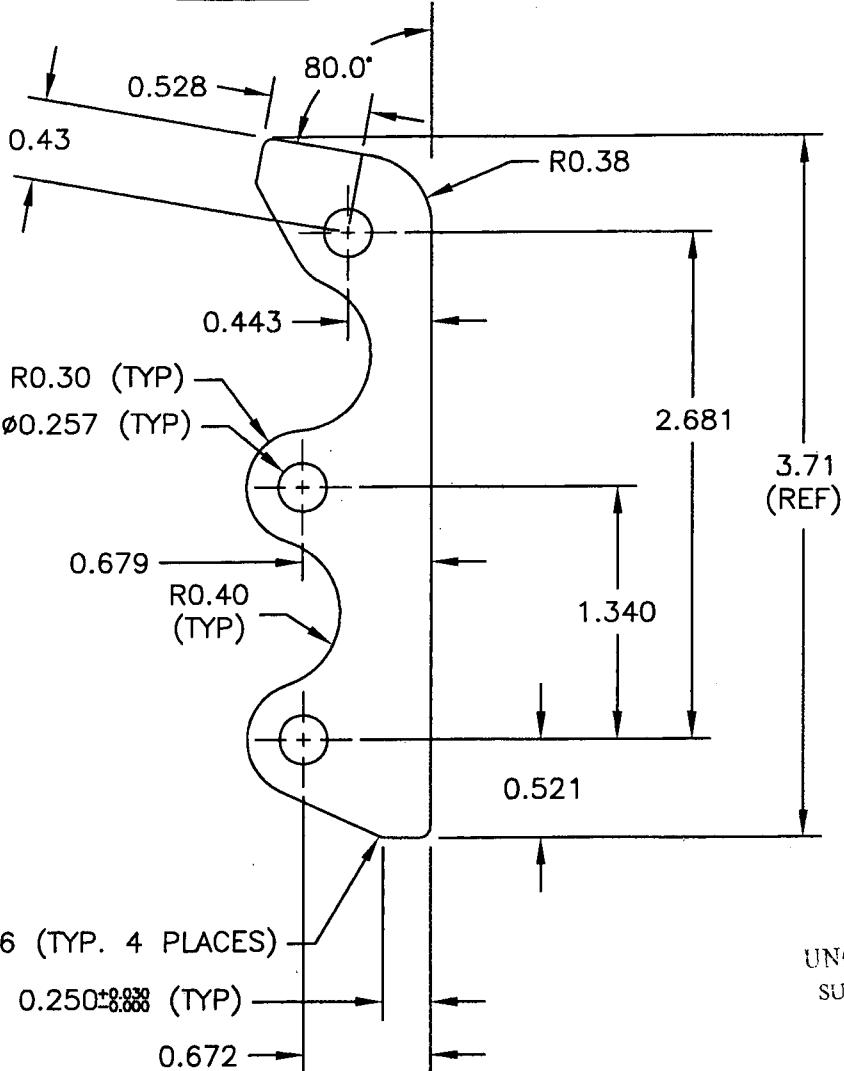
X First Article Prototype

Measured by: <u>KB</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: 8-2-20	Date: 080220	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2885
PH		REV. B SHEET 1 OF 1
DATE		SCALE 1:1
06.05.29		TITLE SADDLE SPACER
A	99.04.01	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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